

AMENDMENT TO THE CLAIMS

54. (Currently amended) A non-detachable metallic end closure with a permanently attached pull tab, comprising:

a center panel;

a seaming panel positioned on a peripheral edge of said center panel which is adapted for interconnection to a neck of a container;

a pull tab having a grip portion on one end and a nose portion on an opposite end and an attaching portion positioned therebetween;

a rivet operably interconnecting said attaching portion of said pull tab to said center panel, wherein said pull tab has a first position prior to opening which is substantially parallel to a horizontal plane of said center panel, and a second position of opening wherein said pull tab is aligned substantially perpendicular to said horizontal plane of said center panel after fully opening ~~said a~~ tear panel provided on said center panel;

at least one projection integrally formed in said center panel and extending upwardly therefrom, said at least one projection positioned substantially adjacent to an edge of said attaching portion to prevent rotation of said pull tab and said attachment portion when the pull tab is in both the first position and said second position; and wherein the at least one projection has an asymmetrical shape with variable steep flanks that are non parallel to each other.

55. (Previously presented) The non-detachable metallic end closure of claim 54, wherein the at least one projection extends over at least 50 % of a width of the attaching portion.

56. (Previously presented) The non-detachable metallic end closure of claim 54, wherein said at least one projection is positioned proximate to one or more edges of the attaching portion.

57. (Currently amended) The non-detachable metallic end closure of claim 54, wherein said at least one ~~of said~~ projection has a linear geometric shape.

58. (Currently amended) The non-detachable metallic end closure of claim 54, wherein at least one of said at least one projection has an oval shape or round geometric shape.

59. (Previously presented) The non-detachable metallic end closure of claim 54, wherein the attaching portion is substantially rectangular in shape and includes at least three outer edge portions which may engage said at least one projection.

60. (Previously presented) The non-detachable metallic end closure of claim 54, wherein the attaching portion is connected to an articulation line on said pull tab wherein the pull tab is tiltable around the attaching portion when actuating the grip portion.

61. (Currently amended) The non-detachable metallic end closure of claim 54, wherein the ~~limiting or blocking of the pivoting movement of the tab~~ the prevention of rotation of said pull tab and said attachment portion is maintained between the first position and the second position.

62. (Cancelled) The non-detachable metallic end closure of claim 54, wherein the at least one projection has an asymmetrical shape with variable steep flanks or sides that are non parallel to each other.

63. (Currently amended) A non-detachable metallic lid interconnected to a can body, the lid comprising:

a central panel including a score panel having a weakening line defining an openable area;

a non-removable pull tab including a grip portion, an opening portion and an attaching portion positioned therebetween, wherein the pull tab is initially oriented in a first position which is substantially parallel with respect to the central panel;

a rivet which is operably connected to said attaching portion of said pull tab wherein the pull tab can be pivoted between the first position and a second position of opening, wherein the pull tab is oriented between about 45-90 degrees with respect to the horizontal plane of the central panel;

the central panel comprising at least one strip-shaped projection resulting from an initial pre-forming from the panel and is structured and arranged in a final shape by a reforming, whereby the thickness of a top side of the strip-shaped projection is flattened and stiffened, and a first flank of the strip-shaped projection is shaped more steeply than a second flank of the projection during reforming to provide enhanced strength characteristics of said metallic lid;

wherein the at least one strip-shaped projection has an asymmetrical shape with variable steep flanks that are non parallel to each other;

the first flank of the strip-shaped projection being structured and arranged for engagement with at least one edge of the attaching portion of the pull tab to ~~limit or block~~ substantially prevent a pivoting movement of the tab in both a first position of use ~~or and~~ a second position of opening, and without overlapping any portion of the attaching portion.

64. (Previously presented) The non-detachable metallic lid of claim 63, wherein the at least one strip shaped projection has a height of at least 0.012 inches as measured from a top side facing outwards of the panel around the projection.

65. (Previously presented) The non-detachable metallic lid of claim 63, wherein the height of the at least one strip shaped projection is not less than substantially the thickness of the sheet metal at the a respective outer edge portion of the attaching portion.

66. (Previously presented) The non-detachable metallic lid of claim 63, wherein the at least one strip shaped projection is located in a peripheral area of a rivet base zone in the lid, such that the rivet base zone is visible from an inside or a product side.

67. (Previously presented) The non-detachable metallic lid of claim 63, wherein a part of the strip shaped projection is located outside the rivet base zone.

68. (Previously presented) The non-detachable metallic lid of claim 63, wherein more than 40 % of a surface area of the at least one strip shaped projection is located outside the rivet base zone.

69. (Previously presented) The non-detachable metallic lid of claim 63, wherein the rivet base zone extends as a mounting place annularly about a rivet, which is visible from the inside or the product side.

70. (Previously presented) The non-detachable metallic lid of claim 63, wherein the at least one strip shaped projection is positioned as a secant to a tangent as a strip or a line in a edge portion of the rivet base zone.

71. (Previously presented) The non-detachable metallic lid of claim 63, wherein the at least one strip shaped projection has the length of more than 80% of the width of the attaching portion.

72. (Previously presented) The non-detachable metallic lid of claim 63, wherein the at least one strip shaped projections are located near at least one portion of two or more edges of the attaching portion.

73. (Previously presented) The non-detachable metallic lid of claim 63, wherein the at least one strip shaped projection extends in a longitudinal direction of the tab and has a length that is not more than 50 % of a longitudinal extension of the attaching portion, and in combination with a distance of the outermost end of the at least one projection from a center of the mounting place of the more than 50 % of the longitudinal extension of the attaching portion.

74. (Previously presented) The non-detachable metallic lid of claim 63, wherein the at least one strip shaped projection comprises at least three projections, two of which extend substantially parallel to a longitudinal axis of the non-removable pull tab and one extending substantially perpendicular to the axis of the non-removable pull tab.